

**Claims**

- 5        1. A method for the manufacture of hinge-lid boxes **characterized** in that the method comprises steps wherein and the collar is glued to the packet portion of the hinge-lid box by applying the glue as horizontal uniform glue lines on the blank of the collar and/or horizontally on the respective area of the blank of the box part, which the collar will be attached to and the number of horizontal glue lines is at least two.
- 10      2. A method according to claim 1 for the manufacture of hinge-lid boxes **characterized** in that the number of glue lines is at least three.
- 15      3. A method according to claim 1 or 2, **characterized** in that the glue lines are applied so that at least one glue line horizontally crosses the whole blank of the collar and at least one glue line crosses horizontally the lower part of the collar blank and the geometry of the glued area is line or strip shape.
- 20      4. A method according to any one of claims 1- 3, **characterized** in that the glue lines form a uniform surface covering the whole area of the collar blank, which remains covered in the finished box.
- 25      5. A method according to any one of claims 1- 4, **characterized** in that the hinge-lid box comprises a single one piece blank or it comprises two blanks, the other being the blank for the collar, or it comprises more than two blanks.
6. A method according to any one of claims 1- 4, **characterized** in that the collar is printed and/or coated.

7. A method, characterized in that the method comprises steps wherein the glue is applied as horizontal uniform glue lines on the blank of the collar and/or horizontally on the respective area of the blank of the box part, which the collar will be attached to and the number of horizontal glue lines is at least two.  
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8. A method according to claim 7 for gluing of the collar to the packet portion of the hinge-lid container characterized in that the number of glue lines is at least three.
- 10 9. A method according to claim 7 or 8, characterized in that the glue lines are applied so that at least one glue line horizontally crosses the whole blank of the collar and at least one glue line crosses horizontally the lower part of the collar blank and the geometry of the glued area is line or strip shape.
- 15 10. A method according to any one of claims 7- 9, characterized in that the glue lines form a uniform surface covering the whole area of the collar blank, which remains covered in the finished box.
11. A method according to any one of claims 7- 10, characterized in that the  
20 hinge-lid box comprises a single one piece blank or it comprises two blanks, the other being the blank for the collar, or it comprises more than two blanks.
12. A method according to any one of claims 7- 11, characterized in that the collar is printed and/or coated.